

54545 Deren.

Work Order ID 53836



Page 1

November 19, 2009 9:02:09 AM

Item ID: D3648-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Driveshaft Tunnel Assembly

Start Date: 19/11/2009 Start Qty: 200



Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

09/11-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3648

Rev B

100

Pick Kit

0.00



Packaging

Memo

0.00

SB 09/12/09

Packaging

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Assemble as per dwg D3648 2- Seal mating surface and all gaps as per dwg D3648 with □ Proseal 700 fire wall sealant □ batch: M110624

9509/12/08

SB 09/12/08

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

278 09/12/10

Quality Control

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53836

November 19, 2009 9:02:09 AM



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Item ID: D3648-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Driveshaft Tunnel Assembly

Start Date: 19/11/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
	Packaging	Memo							
	Packaging								
140	QC21- Final Inspection - Work Order Release	0.00							
	QC	Memo							
	Quality Control								

9/12/11 (2x) SP

09/12/14
MF 09-12-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 19, 2009 9:02:17 AM

Page 1

Work Order ID: 53836

Parent Item: D3648-041RevB

Parent Item Name: Driveshaft Tunnel Assembly






Start Date: 19/11/2009

Required Date: 25/11/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10  WASHER		Purchased	No			100	Each	231.0000	80.0000			
<div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>111965</div> </div> <div>Loc Qty</div> <div>231</div> <div>231</div> <div>Loc Code</div>												
AN3C3A  Bolt		Purchased	No			110	Each	513.0000	80.0000			
<div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>110715</div> <div>111916</div> </div> <div>Loc Qty</div> <div>513</div> <div>50</div> <div>463</div> <div>Loc Code</div>												
X D3649-041RevB  Tunnel Bottom Panel Assembly		Manufactured	No			110	Each	0.0000	2.0000			
<div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>110715</div> <div>111916</div> </div> <div>Loc Qty</div> <div>513</div> <div>50</div> <div>463</div> <div>Loc Code</div>												
S D3650-041RevC  Tunnel Top Panel Assembly		Manufactured	No			110	Each	0.0000	2.0000			
<div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>110715</div> <div>111916</div> </div> <div>Loc Qty</div> <div>513</div> <div>50</div> <div>463</div> <div>Loc Code</div>												
X D3651-041RevB  Aft Base Assembly		Manufactured	No			110	Each	0.0000	2.0000			
<div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>110715</div> <div>111916</div> </div> <div>Loc Qty</div> <div>513</div> <div>50</div> <div>463</div> <div>Loc Code</div>												

80 SB 09/12/10

80 SB 09/12/10

80 SB 09/12/10

SB 09/12/10

SB 09/12/10

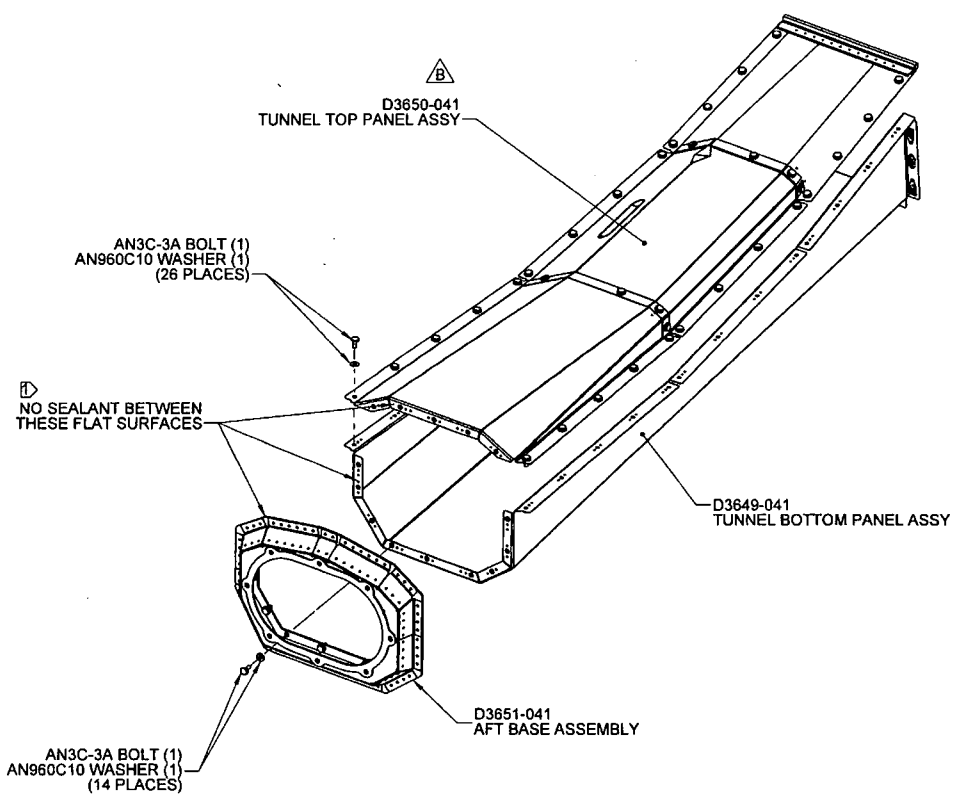
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

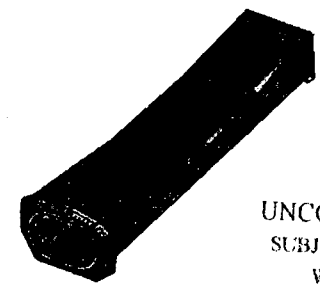
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3648-041 DRIVE SHAFT TUNNEL ASSEMBLY

- NOTES:**
- 1) SEAL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT EXCEPT WHERE NOTED
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3648-041 USING FINE POINT PERMANENT INK MARKER
 - 7) TORQUE FASTENERS TO 15-25 in-lb
 - 8) WEIGHT: 9.2 lbs



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SUBJECT TO APPROVAL
WITHOUT APPROVAL
WORK COPY
NO 5383

PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3648-041	DRIVE SHAFT TUNNEL ASSEMBLY
1	D3649-041	TUNNEL BOTTOM PANEL ASSEMBLY
1	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3651-041	AFT BASE ASSEMBLY
40	AN3C-3A	BOLT
40	AN960C10	WASHER

RELEASED
08.03.27

B	UPDATE WITH REVISED D3650-041	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3648	SHEET 1 OF 1
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	DRIVE SHAFT TUNNEL ASSY	1:6
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	